

Work Order ID 76377

76377

Page 1

November-11-11-9:17:44 AM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 11/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 18/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/11 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2573 | Rev E |

| | | | | | | | | | |
|-----|--------------------------------|------|--|--|--|--|--|--|--|
| 100 | HAAS CNC VERTICAL MACHINING #1 | 0.00 | <div style="display: flex; justify-content: space-between;"> <div> *100* HAAS 1 HAAS CNC vertical machine #1 </div> <div> Memo Program Batch No. <u>76377</u> Double check by: <u>SG</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3- Machine Step No 3 per Folio FA051 and insp </div> <div> <u>SG 11/11/14</u> </div> <div> <u>6</u> <u>0</u> </div> </div> | | | | | | |
|-----|--------------------------------|------|--|--|--|--|--|--|--|

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|-----|------------------------------|------|--|--|--|--|--|--|--|
| 110 | CONVENTIONAL MILLING MACHINE | 0.00 | <div style="display: flex; justify-content: space-between;"> <div> *110* Mill Conv Conventional Milling Machine </div> <div> Memo Machine keyway as per dwg D2573 & D2574 </div> <div> <u>SG 11/11/12</u> </div> <div> <u>6</u> <u>0</u> </div> </div> | | | | | | |
|-----|------------------------------|------|--|--|--|--|--|--|--|

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|-----|---|------|---|--|--|--|--|--|--|
| 120 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | <div style="display: flex; justify-content: space-between;"> <div> *120* QC Quality Control </div> <div> Memo </div> <div> <u>SG 11/11/14</u> </div> <div> <u>6</u> <u>0</u> </div> </div> | | | | | | |
|-----|---|------|---|--|--|--|--|--|--|

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 76377

76377

Page 2

November-11-11 9:17:44 AM

Item ID: D2573 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Aft Out 205
 Start Date: 11/11/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 18/11/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 2 11-11-23 | | 6 | | | |
| 140 *140* HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 6 | DR 11-11-23 | | |
| 150 *150* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo | 0.00 0.00 | | | | | | | |

START TIME: 10:15 FINISH TIME: 10:45 OVEN TEMPERATURE:

32001F

10:45

M 118434

6X0M-11/11/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 76377

76377

Page 3

November-11-11 9:17:44 AM

Item ID: D2573

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle, Aft Out 205

Start Date: 11/11/2011 Start Qty: 6.00

6

Cust Item ID:

Required Date: 18/11/2011 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | QC3- Inspect Part Finish | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

6 BR 11-11-23.

6 8p 11-11-23.

11/11/23

LMF
11-11-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Page 1

November-11-11 9:17:49 AM

Work Order ID: 76377

76377

Parent Item: D2573

D2573

Parent Item Name: Saddle, Aft Out 205

Start Date: 11/11/2011

Required Date: 18/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: I As Per RevE 06-01-27 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D6101-007 | | Manufactured | No | | | 100 | Each | 57.0000 | 1 | 6 | | | |

D6101-007

Saddle Billet

Location

Loc Qty

Loc Code

MAT

8

71722

8

MAT042

10

72228

2

73421

8

MAT045

39

65383

1

65954

4

70680

6

→ 73421

8

74781

20

6

amk 11/11/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

| | |
|--|---------------------------|
| DART AEROSPACE LTD | Work Order: 76377 |
| Description: Saddle, Aft Outboard | Part Number: D2573 |
| Inspection Dwg: D2573 Rev. E | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| Dim | Min | Max | Go/No Go Gauge | Recorded Actual Dimensions | | | | By | Date |
|---------------|-------|-------|----------------|----------------------------|--------|--------|-------|----|------|
| | | | | 1 | 2 | 3 | 4 | | |
| A | 0.438 | 0.443 | | .440 | .440 | .440 | .440 | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | 3.500 | 3.500 | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | 1.750 | 1.750 | | |
| E | 7.990 | 8.010 | | 8.001 | 8.001 | 8.001 | 8.000 | | |
| F | 0.490 | 0.510 | | .501 | .501 | .501 | .500 | | |
| G | 0.257 | 0.262 | | .259 | .259 | .259 | .259 | | |
| H | 0.375 | 0.380 | | .377 | .377 | .377 | .377 | | |
| I | 0.490 | 0.510 | | .501 | .502 | .501 | .502 | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| K | 0.558 | 0.578 | | .569 | .569 | .569 | .569 | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | 1.179 | 1.179 | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | 1.370 | 1.370 | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | 2.500 | 2.500 | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | 4.124 | 4.124 | | |
| P | 0.115 | 0.135 | | .126 | .125 | .125 | .125 | | |
| Q | 0.115 | 0.135 | | .135 | .135 | .135 | .135 | | |
| R | 0.240 | 0.260 | | .250 | .249 | .250 | .250 | | |
| S | 0.115 | 0.135 | | .130 | .130 | .130 | .129 | | |
| T | 0.178 | 0.198 | | .188 | .188 | .188 | .188 | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | 3.230 | 3.230 | | |
| V | 0.230 | 0.250 | | .240 | .247 | .248 | .232 | | |
| W | 0.115 | 0.135 | | .131 | .130 | .130 | .129 | | |
| X | 0.308 | 0.313 | | .310 | .311 | .311 | .310 | | |
| Y | 0.760 | 0.765 | | .762 | .762 | .762 | .762 | | |
| Z | 0.352 | 0.372 | | .363 | .363 | .363 | .363 | | |
| AA | 0.470 | 0.530 | | .500 | .500 | .500 | .500 | | |
| AB | 0.615 | 0.635 | | .619 | .619 | .619 | .619 | | |
| AC | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | | |
| AD | 0.240 | 0.260 | | .249 | .247 | .246 | .246 | | |
| AE | 1.500 | 1.520 | | 1.505 | 1.512 | 1.5125 | 1.513 | | |
| AF | 0.115 | 0.135 | | .130 | .130 | .130 | .130 | | |
| AG | 0.240 | 0.280 | | .275 | .275 | .275 | .275 | | |
| AH | 0.240 | 0.260 | | .250 | .247 | .248 | .247 | | |
| AI | 2.000 | 2.020 | | 2.0015 | 2.0025 | 2.0025 | 2.003 | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | .033 | .033 | | |
| Accept/Reject | | | | | | | | | |

| | |
|--------------|--------------------|
| Measured by: | <i>[Signature]</i> |
| Date: | 11/11/14 |

| | |
|-------------|--------------------|
| Audited by: | <i>[Signature]</i> |
| Date: | 11-11-23 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|--------------------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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|--|--|---------------------------|
| DART AEROSPACE LTD | | Work Order: 76374 |
| Description: Saddle, Aft Outboard | | Part Number: D2573 |
| Inspection Dwg: D2573 Rev. E | | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|---------------|-------|-------|----------------|----------------------------|-------|---|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 15 | 26 | 3 | 4 | By | Date |
| A | 0.438 | 0.443 | | .440 | .440 | | | | |
| B | 1.745 | 1.755 | | 1.750 | 1.750 | | | | |
| C | 3.495 | 3.505 | | 3.500 | 3.500 | | | | |
| D | 1.745 | 1.755 | | 1.750 | 1.750 | | | | |
| E | 7.990 | 8.010 | | 8.001 | 8.000 | | | | |
| F | 0.490 | 0.510 | | .501 | .501 | | | | |
| G | 0.257 | 0.262 | | .259 | .259 | | | | |
| H | 0.375 | 0.380 | | .377 | .377 | | | | |
| I | 0.490 | 0.510 | | .502 | .501 | | | | |
| J | 1.174 | 1.184 | | 1.179 | 1.179 | | | | |
| K | 0.558 | 0.578 | | .569 | .569 | | | | |
| L | 1.174 | 1.184 | | 1.179 | 1.179 | | | | |
| M | 1.365 | 1.375 | | 1.370 | 1.370 | | | | |
| N | 2.495 | 2.505 | | 2.500 | 2.500 | | | | |
| O | 4.119 | 4.129 | | 4.124 | 4.124 | | | | |
| P | 0.115 | 0.135 | | .125 | .125 | | | | |
| Q | 0.115 | 0.135 | | .135 | .135 | | | | |
| R | 0.240 | 0.260 | | .250 | .250 | | | | |
| S | 0.115 | 0.135 | | .129 | .129 | | | | |
| T | 0.178 | 0.198 | | .188 | .188 | | | | |
| U | 3.210 | 3.250 | | 3.230 | 3.230 | | | | |
| V | 0.230 | 0.250 | | .238 | .240 | | | | |
| W | 0.115 | 0.135 | | .129 | .131 | | | | |
| X | 0.308 | 0.313 | | .311 | .311 | | | | |
| Y | 0.760 | 0.765 | | .763 | .763 | | | | |
| Z | 0.352 | 0.372 | | .363 | .363 | | | | |
| AA | 0.470 | 0.530 | | .500 | .500 | | | | |
| AB | 0.615 | 0.635 | | .619 | .619 | | | | |
| AC | 0.053 | 0.073 | | .063 | .063 | | | | |
| AD | 0.240 | 0.260 | | .247 | .247 | | | | |
| AE | 1.500 | 1.520 | | 1.512 | 1.510 | | | | |
| AF | 0.115 | 0.135 | | .130 | .130 | | | | |
| AG | 0.240 | 0.280 | | .280 | .280 | | | | |
| AH | 0.240 | 0.260 | | .248 | .250 | | | | |
| AI | 2.000 | 2.020 | | 2.002 | 2.001 | | | | |
| AJ | 0.023 | 0.043 | | .033 | .033 | | | | |
| Accept/Reject | | | | | | | | | |

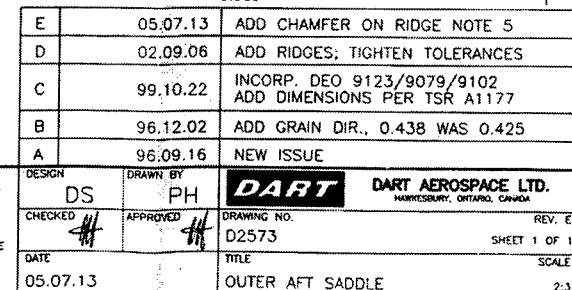
| | |
|--------------|----------|
| Measured by: | am |
| Date: | 11/11/15 |

| | |
|-------------|----------|
| Audited by: | J |
| Date: | 11-11-23 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---|------------|----------|
| A | | New Issue | RF | |
| B | 02.09.26 | Re-format; Added Rev. D | KJ | |
| C | 02.10.11 | Re-format; Added DT8682, DT8683, DT8684 | KJ | |
| D | 05.05.05 | Added dimension AI | KJ/RF | |
| E | 05.12.05 | Added dimension AJ | KJ/JLM | |

WITHOUT NOTICE
WORK ORDER
NO. 76377

05.12.06 77



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AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries